

(19)



Europäisches Patentamt

European Patent Office

Office européen des brevets

(11) Publication number.

0 068 830
A1

(12)

EUROPEAN PATENT APPLICATION

(21) Application number: 82303307.1

(51) Int Cl: A 61 L 15/00

(22) Date of filing: 24.06.82

(20) Priority: 28.06.81 GB 8119739

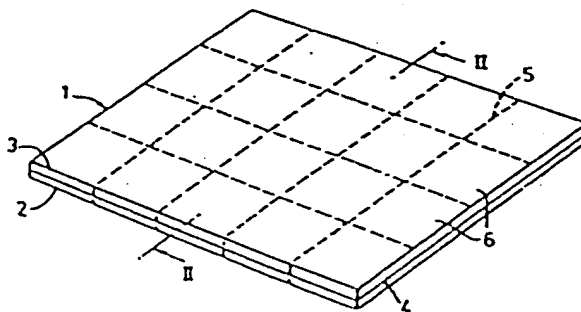
(43) Date of publication of application: 05.01.83
Bulletin 83/1(24) Designated Contracting States: AT BE CH DE FR GB IT
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(54) Substrate carrying a porous polymeric material.

(57) An article suitable for delivering or absorbing liquid includes a substrate carrying a pressure-sensitive porous polymeric material which is capable of retaining at least 10 times its own weight of water or corresponding amounts of other liquids. The porous polymeric material is advantageously a crosslinked homogeneous block material having a dry density of less than 0.1 g/cc and a pore volume of more than 9 cc/g, and may be produced by polymerisation of a high internal phase emulsion. In the article of the invention, the polymer may either be dry or contain an included liquid; the dry form is highly absorbent and is useful for mopping up spillages, while the liquid-containing form is useful for delivering treatment liquids, for example, cleaning compositions, to surfaces. The article may take the form of a single- or multi-compartment sachet of paper or nonwoven fabric containing the porous polymeric material.



SUBSTRATE CARRYING A POROUS POLYMERIC MATERIAL

The present invention relates to an article suitable for wiping a surface, for example, the surface of a household or industrial object, or the human skin, in order
5 either to deliver a liquid active material to that surface or to pick up liquid from that surface; or for gradually releasing an active material, such as a bubble bath composition, an air-freshener or a perfume, without surface contact. The article includes a substrate which in one
10 embodiment of the invention carries a liquid active material, for example, a detergent, or a skin treatment material.

Various wet tissues and towelettes are available in the market for various purposes for example, for personal
15 cleansing or baby hygiene. Articles of this type have to have quite a high liquid content if they are to give adequate cleansing, and this means that moistureproof packaging is essential. One approach to this problem is to package the articles individually in moistureproof sachets,
20 as is done, for example, with the moist towelettes provided by airlines. This is, however, an expensive solution. More recently there have appeared on the retail market packs of wet tissues for personal cleansing in which a roll of moist tissue perforated at suitable intervals is
25 contained in a moisture tight container with a tight closure through which tissues can be drawn out and torn

off. These containers are generally of fairly elaborate design and are expensive to produce.

The need for moistureproof packaging can be obviated if the liquid is carried on the substrate in a protected form so that the overall article is dry up to the point of use. One method of protecting the liquid is to encapsulate it in microcapsules which can be incorporated into or coated onto a substrate and which can be ruptured by the application of pressure, as described, for example, in GB 1 304 375 (L'Oréal).

We have now discovered a convenient alternative method by means of which a substrate article may be produced which has a high liquid content yet which may be dry up to the point of use. This is achieved by including the liquid in a porous polymeric material from which it can be released only by the application of pressure. Furthermore, a substrate carrying such a porous polymeric material in the dry state, that is to say, without an included liquid, can be useful as an absorbent wiper for mopping up spilt liquids.

Accordingly, the present invention provides an article suitable for delivering or absorbing a liquid, the article comprising a substrate carrying a pressure-sensitive porous polymeric material capable of retaining at least 5 times, and preferably at least 10 times, its own weight, defined in terms of water, of liquid, and of releasing at least some of that liquid on the application thereto of hand pressure, the porous polymeric material being dry or containing an aqueous or non-aqueous liquid.

The present invention thus has two main aspects within this generic concept. The first is an article suitable for absorbing liquid, for example from a surface,

said article comprising a substrate carrying a dry porous polymeric material capable of absorbing and retaining at least 10 times its own weight, defined in terms of water, of liquid.

- 5 This article according to the invention has an exceptionally high absorbency for liquids and is thus useful for mopping up liquid spillages.

- 10 The second aspect of the invention is an article suitable for delivering a liquid active material, said article comprising a substrate carrying a porous polymeric material capable of retaining at least 10 times its own weight of liquid, defined in terms of water, and of releasing at least some of that liquid on the application thereto of hand pressure, the porous polymeric material
15 containing an active liquid material.

 The term "active liquid material" is used to indicate a liquid that can usefully and beneficially be delivered by the article of the invention.

- 20 The polymer/liquid composite included in the article of the invention (in its second aspect) preferably consists to an extent of at least 90%, more preferably at least 95%, by weight, of liquid.

- 25 The polymer is such that the liquid contained in it remains enclosed within the polymer unless expressed by the application of hand pressure; the liquid-containing polymer can consist of up to 98% by weight of liquid while feeling virtually dry to the touch. Thus an article containing a high proportion by weight of entrapped liquid can be produced. The liquid can be hydrophobic or hydrophilic
30 depending only on the intended use. Articles of this general type may be used for many purposes, for example,

hand and face cleaning; skin treatment other than cleaning
(for example anti-acne treatment); baby hygiene; cleaning,
polishing, disinfecting or deodorising industrial and
domestic surfaces (for example, windows, paintwork,
5 machinery, carpets, clothing, shoes); air freshening and
perfume delivery; and hospital hygiene.

The article can remain dry during handling and
storage, until the liquid in the polymer is released at the
point of use by the application of pressure. It is also
10 within the scope of the invention for the article to be
wet, for example, impregnated, either with the liquid
contained in the polymer or with a different liquid. If a
second liquid is present, this may not necessarily be
compatible with the first, since mixing will not occur
15 until the polymer is squeezed in use. As mentioned in more
detail below, an article of the invention may include a
plurality of separate regions of polymeric material
containing the same or different liquids, and any
additional liquid present outside the polymer may be the
20 same or different from any of the polymer-included liquids.

One or more further liquids may if desired be
present in microencapsulated form. This is especially
advantageous in the case of mutually incompatible liquids.

Preferably the porous polymeric material is capable
25 of retaining at least 15 times, more preferably at least 25
times, and especially at least 40 times, its own weight of
liquid, defined in terms of water. It will not necessarily
be capable of absorbing these quantities of all types of
liquid spontaneously; in some cases suction may be
30 necessary to assist the introduction of liquid. It is,
however, essential that once the liquid is inside the pore
system of the polymer it remains there unless the polymer

is squeezed, apart of course from the unavoidable slow loss of liquid by evaporation.

It is thus essential that the porous polymeric material combines a high capacity for liquid with an ability to retain the liquid unless subjected to pressure. There must be little or no tendency for the liquid to run out of the polymer under the influence of gravity; the liquid should remain distributed throughout the material until expressed by pressing or squeezing the material at hand pressure. After the liquid has been expressed, the material may not regain its original shape or pore structure.

This combination of properties may be found in a material having relatively large voids interconnected only by relatively narrow passageways. On squeezing there is a partial collapse of the structure allowing escape of the liquid.

The polymer preferably has a pore volume greater than 9 cc/g, more preferably greater than 15 cc/g.

The dry density of the polymer is preferably less than 0.1 g/cc, more preferably within the range of from 0.03 to 0.08 g/cc. This is the density of the material when its pore system contains air. Some polymers that can be used in the article of the invention, however, cannot exist in the dry state; they are prepared by methods which leave the pore system full of liquid, and this liquid can if desired be exchanged for another liquid, but if dried their pore system collapses. Such materials are useful in the second aspect of the invention although inherently unsuitable for use in the first aspect of the invention.

Various polymers suitable for use in the present invention have been described in the literature. Techniques for the production of porous polymers range from what is termed, in the art, classical phase inversion, to nuclear bombardment, the incorporation of microporous solid particles in a matrix material followed by the leaching out of the particles, and the sintering together of microporous particles.

The porous polymeric material used in the article of the invention may if desired be in the form of beads, either discrete or coalesced. Such porous polymer beads are disclosed, for example, in GB 1 513 939 (Ceskoslovenska Akademie Ved); they are prepared by dissolving the polymer to be used in a solvent and then dispersing the solution into a compatible carrier liquid, and adding this mixture to a coagulating liquid such as water to precipitate the porous beads of polymer. If desired, the beads may be subsequently coalesced to form a moulding.

Preferably, however, the porous polymeric material that forms part of the article of the invention is, at least initially, in the form of homogeneous block or sheet material. Such material has the advantage that it will be substantially homogeneous or uniform in its porosity, and will then deliver or absorb liquid in a uniform and predictable manner. The polymeric material in block or sheet form may of course be cut down into smaller pieces, or even ground into powder, before use. In the case of a liquid-containing polymer, this will entail some loss of liquid but this can generally be tolerated.

One homogeneous porous polymeric material suitable for use in the article of the invention is described and claimed in GB 1 576 228 (Akzo). This patent specification discloses thermoplastic microporous cellular structures

comprising microcells (pores) having an average diameter of 0.5 - 100 μ m connected by smaller-diameter passageways, the size distribution of the latter being a defined function of the average cell diameter. The structures are composed of a synthetic thermoplastic homopolymer or copolymer of an ethylenically unsaturated monomer, or of a condensation polymer, or of a polyphenylene oxide, or of any blend of these. The structures are prepared by dissolving the thermoplastic polymer in a suitable solvent at elevated temperature, cooling the solution to solidify the polymer, and then removing the liquid from the resulting solid structure. These materials generally have void volumes of 70-80%, and can retain about 5 times their own weight of liquid (defined in terms of water). The Akzo process is of course limited in its application to thermoplastic polymers, and to polymers that can readily be dissolved in appropriate solvents, but within these limits yields materials highly suitable for use in the article of the invention.

20 An alternative route to porous polymeric materials having the requisite pore and passageway structure involves solution or emulsion polymerisation of an organic film-forming polymer under controlled conditions. In particular, according to a highly preferred embodiment of the invention, the polymer may be prepared by polymerisation of a high internal phase emulsion in which the internal phase is aqueous and the continuous phase comprises one or more polymerisable monomers. This method can give polymers capable of retaining at least 10 times their own weight of liquid (defined in terms of water).

30 The higher the proportion of the aqueous internal phase in the starting emulsion, the higher will be the void volume in the final polymer. Thus the aqueous phase

preferably constitutes at least 90%, more preferably at least 95%, by weight of the emulsion.

It has been observed from microscopic inspection of samples of the porous polymer made by this method that it
5 essentially comprises a series of substantially spherical, thin-walled cavities having a plurality of very small holes in the walls interconnecting the adjacent cavities. Frequently six or more holes can be seen in the cavities on inspection of electron micrographs of polymer samples. It
10 has been determined that the liquid absorbency and retention capacity is related to the size of the cavities, expressed in terms of void diameter, and the number and size of the holes in the cavity walls, expressed in terms of pinholes. In general it is desirable that the average
15 pinhole diameter should not be less than 0.5 μ m and the void diameter should be at least 20% greater than that figure.

The polymeric material is advantageously crosslinked.
20 Crosslinking apparently improves the capacity for absorption and retention of liquids and also gives greater dimensional stability.

In the high internal phase emulsion, the continuous phase comprises the monomer(s), and a surfactant (as
25 emulsifier) and a polymerisation catalyst are also present. Preferably the amount of surfactant present is from 5 to 30% by weight, based on the total monomer, and the amount of catalyst present is from 0.005 to 10% by weight, based on the total monomer.

30 The mechanism by which the holes form in the thin-walled cavities is not fully understood. However, experimental work suggests that it is related to the quantity of surfactant present and its compatibility with

the cross-linked polymer and, hence, also, to the degree of cross-linking in the polymer. It is thought that prior to polymerisation the high internal phase emulsion consists of three main elements: monomer and surfactants in the continuous phase and water in the internal phase. The continuous phase, which consists of a homogeneous solution of surfactant and the monomer and cross-linking agent and, in this situation, the surfactant is compatible with the monomer mixture. It is thought that at this stage there are no interconnecting holes present in the external phase. During polymerisation chain propagation takes place and as the surfactant is not polymerisable and has no reactive sites in its structure, it cannot take part in the polymerisation reaction. As a result, the surfactant molecules separate because the surfactant is no longer compatible with the growing polymeric structure and is also insoluble in the water phase. Due to the nature of a surfactant, the aggregated molecules of surfactant remain part of the polymer phase and probably cause the production of weak spots and subsequent pinhole formation in the cross-linked polymer film.

Another factor affecting the structure of the porous cross-linked polymer is the structure of the high internal phase emulsion from which it is formed. This can most readily be defined in concepts of viscosity and Table I and II indicate the effect of stirrer speed on two typical emulsions and show the viscosity of emulsions produced at different stirrer speeds and the detailed structure of the cross-linked porous polymers produced from the emulsions at the different stirring rates.

The basic emulsion used in the work shown in Table I contained 10 ml styrene, 1 ml divinyl benzene and 2 grams of Span (Trade Mark) 80 and 200 ml water containing 0.2% sodium persulphate. The emulsion used for the work in

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Table II was the same except that 300 ml water were used and in each case the preparation was carried out generally as described in Example I below.

5 The emulsions were prepared at stirrer speed of 200 rpm and after all the components had been mixed the samples of the emulsion were stirred at the speeds shown in the Tables for 30 minutes prior to cross-linking to yield the porous cross-linked polymer samples.

10 Viscosity measurements were made used using Brookfield Viscometer fitted with a 'C' spindle at, as shown in the Tables, 10 and 20 rpm.

Table I

	<u>Viscosity of emulsion for polymerisation</u>					<u>Structure of cross-linked polymer (average)</u>	
	10RPM	20 RPM		Inter-		connecting	
	Motor Speed (RPM)	Visco- meter Reading	$\times 10^3$ poise	Visco- meter Reading	$\times 10^3$ poise	Sphere size (μm)	pore size (μm)
15	200	12.3	12.3	14.5	7.3	38.4	5.3
	300	21.8	21.8	24.5	12.3	25.1	4.1
	500	23.2	23.2	26.5	13.3	15.4	2.8
	800	50.8	50.8	55.0	27.5	9.1	1.6
	1000	60.8	60.8	69.9	35.0	8.1	1.4
25	2000	100+	100+			7.1	1.0

Table II

	<u>Viscosity of emulsion for polymerisation</u>					<u>Structure of cross-linked polymer (average)</u>	
	10RPM	20RPM				Inter- connecting pore size (um)	Sphere size (um)
Motor Speed (RPM)	Visco- meter Reading	$\times 10^3$ poise	Visco- meter Reading	$\times 10^3$ poise			
5	200	7.1	7.1	8.0	4.0	45.8	5.4
10	300	13.5	13.5	15.0	7.5	20.0	4.0
	500	18.8	18.8	21.5	10.8	17.1	2.4
	800	34.9	34.9	42.4	21.2	11.7	1.5
	1000	39.7	39.7	46.6	23.3	8.4	1.5
	1500	43.4	43.4	54.1	27.1	9.0	1.3
15	2000	55.6	55.6	61.8	30.9	7.7	0.95

It will be seen from the tables that the emulsion viscosity has a clear relationship with the pore or cavity size of the cross-linked polymer and with the size of the holes or interconnecting passages between the cavities.

Clearly by selecting the appropriate stirrer speed and hence viscosity of the emulsion the size of the cavities in the cross-linked polymer can be quite closely controlled.

In general it will be noted that the ratio of sphere or cavity size to the size of the interconnecting pore or pinhole is of the order of 7:1.

Various monomers may be used in the preparation of those porous polymers by the emulsion method. Vinyl monomers are preferably used, styrene being especially preferred. If the polymer is to be lightly cross-linked, a cross-linking monomer is included in the starting emulsion. A preferred polymer is a lightly cross-linked

polystyrene containing a small proportion of
divinylbenzene. Polymeric materials may also be made
using various acrylate polymers, for example, polymethyl or
polybutyl methacrylate, cross-linked with,
5 for example, allyl methacrylate.

Preferably, the polymerisation catalyst is in the
water phase and polymerisation occurs after transfer of the
catalyst into the oil phase. Alternatively, the
polymerisation catalyst may be introduced directly into the
10 oil phase. Suitable water-soluble catalysts include
potassium persulphate and various redox systems such as
ammonium persulphate together with sodium metabisulphite.
Monomer soluble catalysts include azodibisisobutyronitrile
(AIBN), benzoyl peroxide and di-2-ethyl-hexyl-peroxy-
15 dicarbonate. The temperature at which the polymerisation
is carried out can be varied fairly widely between about 30
and 90°C, but is clearly related to the particular catalyst
initiator employed.

The surfactant used in making the high internal
20 phase emulsion which is to be polymerised is fairly
critical, although the long-term stability of the high
internal phase emulsion is not an important factor provided
that it is long enough to maintain stability during
polymerisation. Using the well known HLB terminology in
25 relation to the surfactants, it is desirable that the
surfactant has an HLB value of less than 6 and more than 2,
preferably about 4. Providing the HLB criterion is met,
many surfactants can be used in the preparation of the
porous polymers. Amongst those suitable may be included:

	<u>Nonionic</u>	<u>H.L.B</u>
	Sorbitan monoleate ("Span" (Trade Mark) 80)	4.3
	Glycerol monoleate	3.8
	Glycerol monoricinoleate	4.0
5	PEG 200 dioleate	4.6
	Partial fatty acid esters of polyglycerol (Admul (Trade Mark) Wol 1403 ex Food Industries Limited of Bromborough, England)	
	Castor oil 5-10 EO	3-6
10	<u>Cationic</u>	
	Distearyl dimethyl ammonium chloride	5-6
	Dioleyl dimethyl ammonium chloride	5-6
	<u>Anionic</u>	
	Bis-tridecyl sulphosuccinic acid (Na salt)	5-6
15	<u>Amphoteric</u>	
	Alkylbenzene sulphonate/C ₁₈ amine oxide complex	
20	<p>* Experimental work has shown that the amount of surfactant in the system is critical and that if insufficient surfactant is employed the cavities have insufficient holes to generate the desired absorbency.</p> <p>The optimum concentration of surfactant by weight of monomers is of the order of 20%, but useful results can be obtained in the range of 5 to 30% and preferably, 15-25%.</p>	
25	<p>The polymers used in the article of the invention may be prepared by first forming a water-in-oil high internal phase emulsion system where the oil phase is</p>	

constituted by the monomer or mixture of monomers, together with a small amount of a cross-linking agent. The polymerisation initiator or catalyst can be dissolved in either the water phase or in the oil (monomer) phase. The high internal phase emulsion system is prepared by the slow addition of the aqueous internal phase to the oil (monomer) phase in which the emulsifying agent (surfactant) is preferably dissolved, using a moderate shear stirring. Conveniently the container in which the polymerisation is carried out is enclosed to minimise the loss of volatile monomers and the emulsions are thermally polymerised in the container.

This process gives a polymer in which the void system containing an aqueous liquid - the internal phase of the original emulsion. If desired, this liquid can be readily removed by subjecting the polymer to a vacuum or leaving the material to dry in a dry atmosphere at between about 30 and 60°C. The dry polymer thus obtained may be used to form a dry article according to the first aspect of the invention, which as indicated previously, is very useful for mopping up spillages of hydrophobic liquids. One polymer which is described and claimed in British Patent Application No 81 07658 and European Patent Application No 82301199.4, the disclosures of which are hereby incorporated by reference, is exceptionally useful for absorbing hydrophobic liquids and has an absorbency for such liquids, defined in terms of oleic acid, of at least 7 cc/g.

In articles according to the second aspect of the invention, the void system of the polymer contains a liquid. Starting from a high internal phase emulsion, the liquid-containing polymer may be prepared in three ways:

- (a) a dry polymer may be prepared as described above, and the desired liquid subsequently introduced;
- 5 (b) the liquid initially present in the polymerised high internal phase emulsion may be exchanged for the desired liquid;
- (c) the desired liquid may itself be used as the internal phase of the emulsion.

10 When method (a) is used, the polymer may spontaneously take up the desired liquid if the polymer is of a type which has a high absorbency for the liquid in question. Otherwise, introduction of the liquid may be vacuum-assisted.

15 Method (b) is a direct substitution of the desired liquid for the original internal phase of the emulsion without an intermediate drying step. The polymer is preferably washed before the introduction of the desired liquid, in order to remove traces of the materials present in the original internal phase, notably the surfactant.

20 Washing with a solvent such as a lower alcohol is highly effective. Where the desired liquid is a detergent composition, the desired liquid may itself be used for the preliminary washing step, although it may then be necessary to wash at a higher than ambient temperature, for example,

25 50°C. Liquid exchange may be carried out as a continuous, vacuum-assisted operation.

30 Method (c) is of course suitable only for certain aqueous liquids that will not destabilise the high internal phase emulsion. In particular, it is not suitable for liquids containing high-HLB surfactants, as do most detergent compositions. One class of liquids that is suitable for inclusion by method (c) is comprised of

aqueous solutions of oxygen bleaches, especially hydrogen peroxide-based bleaches.

5 In the article of the invention the polymer is carried by a substrate. The substrate may be any suitable carrier material that gives integrity to, and provides protection for, the polymer. For convenience of handling, it advantageously comprises one or more layers of flexible sheet material, or a sponge or pad. The substrate is advantageously porous to allow liquid to pass through, and may advantageously be absorbent. In the first aspect of 10 the invention an absorbent substrate adds to the overall absorbency of the article; and in the second aspect of the invention an absorbent substrate will become impregnated with the liquid as the latter is expressed from the polymer and can assist in its distribution, for example, on a hard 15 surface being wiped. Alternatively, as previously mentioned, an absorbent substrate may be impregnated with further liquid which may be the same as, or different from, that included in the polymer. A preferred substrate according to the invention includes one or more sheets of 20 fibrous material, especially wet-strength paper or woven, knitted or nonwoven fabric.

According to a preferred embodiment of the invention (in both aspects) the polymer is completely surrounded by the substrate. Thus the polymer, in the form of beads or a 25 solid block, sheet or film, may be inside a sachet. At least one wall of the sachet must be permeable to liquid in order to allow the passage of liquid into or out of the polymer; thus at least one wall is of inherently permeable material and/or contains openings.

30 Advantageously the sachet walls (substrate) may be formed of a nonwoven fabric/plastic film laminate, at least

one of the walls being provided with one or more perforations to allow the passage of liquid.

Advantageously the article of the invention may consist of a plurality of cells or compartments each of which is in effect a sachet as described above. This type of article may comprise a first substrate layer and a second substrate layer so bonded together as to create a plurality of compartments therebetween, at least some of said compartments containing the porous polymer and at least some of said compartments being liquid-permeable.

Advantageously, at least some of the compartments are provided with one or more perforations.

In use, the polymer itself remains within the compartments but liquid can pass out of or into it through the substrate walls or by way of the perforations.

Advantageously different compartments of the article are provided with different numbers of perforations to allow differing rates of passage of liquid. This is especially advantageous in the case of articles according to the second aspect of the invention, in that it allows for controlled release of the liquid over a relatively long period. This embodiment also allows for the use of polymers containing different liquids in different compartments for release at different rates.

Advantageously the substrate layers include heat-sealable material. The two layers can then be bonded together by welding, for example, by heat sealing or ultrasonic sealing, around the porous polymer. Nonwoven fabric including some thermoplastic fibres, and nonwoven fabric laminated with thermoplastic film, may advantageously be used.

5 If the porous polymer is in discrete form, such as beads, these may be sprinkled onto the first layer and the second layer subsequently heat-sealed to the first. This process may be carried out continuously, for example, using hot rollers.

10 The porous polymer may, however, be in continuous (block, sheet or film) form. A block should first be cut into sheets. If the polymer is itself heat-sealable, a sheet or film may be interposed between two layers of substrate laminate and the whole heat-sealed together, in a continuous operation, for example, using hot rollers.

15 If the porous polymer is not heat-sealable, it may first be cut into compartment-sized pieces, arranged on one substrate layer using a grid-patterned mask to aid positioning, and the second substrate layer then heat-sealed to the first between the polymer pieces.

20 The perforations may be made at any suitable stage in the proceedings. Pre-perforated substrates may if desired be used; this of course requires matching of the perforation pattern to the pattern of bonding between the substrates. Alternatively, the compartments may be perforated after the active material/substrate composite has been made up. In a batch process, perforation may be carried out using a syringe needle.

25 In a continuous process as mentioned above, the perforations may be made on one or both sides of the article, after the two substrates have been bonded together, by passing the composite article over a roller carrying appropriately spaced pins.

30 The perforations may be as small as desired, but will generally be at least 0.01 mm in diameter, preferably

at least 0.1 mm. Perforations of from 0.2 to 1.2 mm are preferred, especially from 0.5 to 1.0 mm. Of course relatively large perforations are suitable only when the active material is not very mobile or is protected as indicated previously.

The distribution of perforations depends on the size of the compartments as well as on the desired rate of release of the active material. The compartments preferably have areas ranging from 0.5 to 5 cm², more preferably from 1 to 3 cm² and especially from 1.5 to 2.5 cm². The compartments may be of any convenient shape; for ease of manufacture the bonding lines separating them are preferably straight and hence parallelogram shapes, such as square, rectangular, rhomboidal (diamond) and the like, are especially preferred.

The average distribution of perforations is advantageously less than 5/cm², and preferably lies between 0.5 and 3/cm². Practicable rates of release of most liquids can be obtained with average perforation levels within this range. Of course the distribution of perforations among the compartments may be either regular or irregular as desired.

In articles according to the second aspect of the invention, where the polymer contains a liquid, the liquid can be any that will deliver a benefit, as previously indicated; it may be hydrophobic or hydrophilic. Examples of such liquids include soap and detergent compositions, bleach, disinfectant, bubble bath and shower preparations, air fresheners, skin treatment agents, dry cleaning solvents, perfumes, and many more.

In one particular embodiment of the second aspect of the invention, the liquid is a cleaning composition that will give substantially streak-free cleaning of reflective household surfaces such as mirror, tiles, paintwork and
5 furniture.

Such an article has the advantage that it can be applied directly to the surface to be cleaned; the surface need only wiped over and then allowed to dry. No additional liquid and no cloths or tissues are required;
10 thus contamination by streak-forming impurities is eliminated.

In this embodiment the liquid in the void system of the porous polymer is a homogeneous aqueous liquid composition having a surface tension of less than 45
15 mNm^{-1} , preferably less than 35 mNm^{-1} , which composition, when applied to a surface and allowed to dry, dries substantially without forming discrete droplets or particles larger than $0.25 \mu\text{m}$.

The formation of discrete droplets or particles
20 larger than $0.25 \mu\text{m}$ on drying causes scattering of visible light (wavelength $0.4\text{--}0.7 \mu\text{m}$), which is perceived by the eye as streaking. Preferably the liquid composition dries substantially without forming discrete droplets or particles larger than $0.1 \mu\text{m}$.

25 In this embodiment it is essential that both the substrate and the polymer be substantially free of streak-forming impurities which might be leached out by the liquid composition and deposited on the wiped surface as streaks. The porous polymers themselves have been found to give no
30 streaking problems provided that they are thoroughly washed (see previously) before introduction of the streak-free liquid composition.

Some substrates may inherently be free of such impurities; many papers or nonwoven fabrics, however, contain binders and some of these can cause streaking problems. Traces of bonding agent, size, clays, fluorescers, fibre lubricants, emulsifiers or other processing materials may also be present in papers and nonwoven fabrics and these can also cause streaking. Accordingly the substrate is preferably pretreated to remove any materials associated therewith that might cause, or contribute to, streaking. The treatment may conveniently comprise prewashing the substrate with a solvent capable of removing the impurities, before the application of the liquid composition. In some cases washing with hot to boiling demineralised water may be necessary, while in others a pre-soaking in an excess of the liquid composition itself may suffice. Some binders used in paper and nonwoven fabrics, notably crosslinked katpolyalkylimine, do not appear to cause streaking problems, and substrates in which only this type of binder is present may not require a prewashing treatment.

The homogeneous aqueous liquid composition for streak-free cleaning may contain, as well as water, one or more water-miscible solvents, but the amount of non-aqueous solvent generally should not exceed 35% by weight, and is preferably within the range of from 0.1 to 15% by weight. Larger amounts of solvent can cause safety problems and may damage certain surfaces such as plastics or paintwork; the presence of limited amounts of solvent is however advantageous in decreasing the drying time of the composition and in facilitating the removal of oily soil.

Typical examples of suitable solvents are the lower aliphatic water-miscible alcohols such as ethanol, propanol, isopropanol, butanol and so on. Other alcohols,

such as tetrahydrofurfurol, may also be used. Glycols such as ethylene- and propylene glycol and glycol ethers, such as the mono- and dimethyl-, -propyl, -isopropyl, -butyl, -isobutyl ethers of di- and triethylene glycol and of analogous propylene glycols may also be used. The preferred solvents are C_2 and C_3 aliphatic alcohols, especially ethanol and isopropanol. The cellosolves and carbitols are also useful solvents in the context of the invention.

10 It will be recalled that the liquid composition for streak-free cleaning has a surface tension of less than 45 mNm^{-1} , and preferably less than 35 mNm^{-1} , in order adequately to wet the surface being wiped. The lowering of surface tension (the value for water is above 70 mNm^{-1})
15 is conveniently achieved by including in the liquid a surface-active agent, preferably at a concentration not exceeding 1.5% by weight. Higher concentrations are unnecessary from the point of view of surface tension lowering and may cause streaking or excessive sudsing. A
20 concentration within the range of from 0.009 to 1% by weight is preferred, and one within the range of from 0.02 to 0.2% by weight is especially preferred.

Although in principle any anionic, nonionic, cationic, zwitterionic or amphoteric surface-active agent
25 may be used, nonionic surface-active agents, which tend to be low-foaming, are especially preferred. In general, nonionic surface-active agents consist of a hydrophobic moiety, such as C_8 - C_{20} primary or secondary, branched or straight chain monoalcohol, a C_8 - C_{18} mono- or
30 dialkylphenol, a C_8 - C_{20} fatty acid amide, and a hydrophilic moiety which consists of alkylene oxide units. These nonionic surface-active agents are for instance alkoxylation products of the above hydrophobic moieties, containing from 2 to 30 moles of alkylene oxide. As

alkylene oxides ethylene-, propylene- and butylene oxides and mixtures thereof are used.

Typical examples of such nonionic surfactants are C_9-C_{11} primary, straight-chain alcohols condensed with from 5-9 moles of ethylene oxide, $C_{12}-C_{15}$ primary straight-chain alcohols condensed with from 6-12 moles of ethylene oxide, or with 7-9 moles of a mixture of ethylene- and propylene oxide, $C_{11}-C_{15}$ secondary alcohols condensed with from 3-15 moles of ethylene oxide, and $C_{10}-C_{18}$ fatty acid diethanolamides. Tertiary amine oxides such as higher alkyl di(lower alkyl or lower substituted alkyl)amine oxides, for example, lauryl di(hydroxymethyl)amine oxide, are also suitable. Further examples may be found in N Schick's textbook "Nonionic Surfactants", M Dekker Inc, New York, 1967. Mixtures of various nonionic surfactants may also be used.

For optimum detergency, the shorter alkyl chain length nonionic surfactants are preferred, particularly when the degree of alkoxylation is relatively low. Thus, the alkoxyated C_9-C_{11} alcohols are preferred over the corresponding alkoxyated $C_{12}-C_{15}$ alcohols, and the C_9-C_{11} alcohols condensed with 5 moles of ethylene oxide are preferred over the same alcohols but condensed with 8 moles of ethylene oxide.

A class of nonionic surfactants that give good streak-free results is comprised by the condensation products of $C_{16}-C_{20}$ alcohols with 15 to 20 moles of ethylene oxide. The condensation product of tallow alcohol with 18 moles of ethylene oxide is especially effective.

Anionic surfactants may also be present, but since these generally tend to foam more than nonionic surfactants they are generally used in smaller amounts, preferably in

concentrations not exceeding 0.15% by weight; foaming is disadvantageous because foam can leave spots as it dries. Preferred anionic surfactants are the alkyl ether sulphates, especially the sulphated condensation products of C_{10} - C_{18} aliphatic alcohols with 1 to 8 moles of ethylene oxide. Secondary alkane sulphonates, alkylbenzene sulphonates, soaps, dialkyl sulphosuccinates, primary and secondary alkyl sulphates, and many other anionic surfactants known to the man skilled in the art, are also possible ingredients.

It will further be recalled that the liquid composition for streak-free cleaning dries, after application to a surface, substantially without the formation of discrete droplets or particles larger than 0.25 μ m, and preferably without the formation of such droplets or particles larger than 0.1 μ m. It is the formation of such particles or droplets, which scatter visible light, which produces streaks on the surface. Avoidance of streak formation on drying may be assisted by including in the liquid composition a film-forming component, preferably but not exclusively an organic film-forming polymer.

The film-forming polymer in the liquid composition is advantageously an at least partially esterified resin, which can be either partly derived from natural sources or wholly synthetic in origin. An example of a resin partly derived from natural sources is the partially esterified adduct of rosin and an unsaturated dicarboxylic acid or anhydride. Examples of wholly synthetic resins are partially esterified derivatives of copolymerisation products of mono-unsaturated aliphatic, cycloaliphatic or aromatic monomers having no carboxy groups, copolymerised with unsaturated dicarboxylic acids or anhydrides thereof. Normally, these copolymers will contain equimolar

proportions of the monomer and the dicarboxylic acid or anhydride, but copolymers with higher ratios of monomer per mole of dicarboxylic acid or anhydride are also suitable, provided that they can be dissolved in the aqueous solvent system used. Typical examples of suitable copolymers are copolymers of ethylene, styrene, and vinylmethylether with maleic acid, fumaric acid, itaconic acid, citraconic acid, aconitic acid and the like and the anhydrides thereof. Preferred are the styrene/maleic anhydride copolymers.

10 The partly natural or wholly synthetic resins are at least partially esterified with a suitable hydroxyl-group-containing compound. Examples of suitable compounds are aliphatic alcohols such as methanol, ethanol, propanol, isopropanol, butanol, isobutanol, ethylhexanol
15 and decanol, glycol ethers such as the butyl ether of ethylene glycol and polyols such as ethyleneglycol, glycerol, erythritol, mannitol, sorbitol, polyethylene glycol, polypropylene glycol; and the hydroxylic nonionic surfactants mentioned above. The choice of suitable
20 esterification agent and the degree of esterification are primarily governed by the solubility requirements of the at least partially esterified resin in an aqueous or aqueous/solvent system of the type previously described, which will generally be alkaline.

25 In the at least partially esterified resin, the degree of esterification is preferably such that from 5 to 95%, more preferably from 10 to 80%, and especially 20 to 75%, of the free carboxy groups of the resin are esterified with the hydroxyl-group-containing compound. The
30 esterification may also be complete.

Suitable examples of preferred partially esterified resins are partially esterified copolymers of styrene with maleic anhydride, for example, Scripset (Trade Mark) 550

(ex Monsanto, USA); partially esterified adducts of rosin with maleic anhydride for example, SR 91 (ex Schenectady Chemicals, USA); modified polyester resins, for example, Shanco (Trade Mark) 334 (ex Shanco Plastics); and
5 polyvinyl methylether/maleic anhydride copolymers partially esterified with butanol, for example, Gantrez (Trade Mark) ES 425 (ex GAF Corporation, USA).

Mixtures of various partially esterified resins may also be used, as well as mixtures of partially esterified
10 and fully esterified or non-esterified resins. Thus, mixtures of Scripset 550 and SR 91, Scripset 550 and Shanco 334, and SR 91 and Shanco 334 give good results, as well as mixtures of Scripset 550 and SMA 2000A (a non-esterified styrene/maleic anhydride copolymer ex Arco Chemical Co.,
15 USA).

The molecular weight of the resins used may vary from about a few thousand to about a few million. The partially esterified resins should have acid numbers high enough to ensure solubility in a neutral or alkaline
20 aqueous medium. The partially esterified resin may if necessary be hydrolysed and subsequently neutralised or made alkaline so that in normal use it is present in the streak-free cleaning composition as the alkali metal, ammonium or substituted ammonium salt, or as the salt of a
25 suitable amine or mixtures thereof.

The concentration of the film-forming resin in the streak-free cleaning composition is preferably within the range of from 0.001 to 5% by weight, more preferably from 0.005 to 1% by weight. At the higher levels the resin
30 alone may be sufficient to lower the surface tension of the composition below the limiting value of 45 mNm^{-1} .

It is preferred, however, to use both a surface-active agent, preferably nonionic or nonionic plus anionic, and a film-forming resin. In this case the weight ratio of surfactant to resin preferably lies within the range of
5 from 15:1 to 1:2, more preferably 10:1 to 1:1.

The streak-free liquid composition contains water, generally in substantial amounts. In most preferred systems it contains at least 80% water, and preferably at least 90%. In systems containing no non-aqueous solvent
10 the water content is preferably at least 95% and may be as much as 99% or more. It is generally preferred to use demineralised water in order to minimise the possibility of streak-forming impurities; where calcium-sensitive active ingredients such as certain anionic surfactants (notably
15 soaps and alkylbenzene sulphonates) are present this is especially important. Accordingly it will not generally be necessary to include a builder in the liquid composition, although the presence of most soluble builders does not, apparently, cause streak formation. On the other hand,
20 with some active ingredients, streak-free drying is actually promoted by the hardness impurities in water. Certain nonionic surfactants, for example, when used alone in demineralised water give streaking because on drying a mist of droplets is formed. When hard water is used
25 instead of demineralised water, however, streak-free drying can be achieved.

In addition to the various components already specified, the liquid composition for steak-free cleaning may if desired contain further, optional ingredients, such
30 as preservatives, colouring agents, perfumes and plasticisers, with, of course, the proviso that such materials do not interfere with the streak-free drying properties of the composition.

According to another preferred embodiment of the second aspect of the invention, the liquid contained in the polymer is a bleach, especially an oxygen bleach and more especially a hydrogen-peroxide-based bleaching composition.

The invention will now be described in further
5 detail, by way of example only, with reference to the accompanying drawings, in which:

Figure 1 is an isometric view of a first article according to the invention;

Figure 2 is a fragmentary section along the line
10 II-II of Figure 1;

Figure 3 is an isometric view of a second article according to the invention; and

Figure 4 is a fragmentary section along the line IV-IV of Figure 3.

15 Referring now to Figures 1 and 2 of the drawings, a first article 1 consists of a lower substrate 2 and an upper substrate 3, each consisting of a single layer of nonwoven fabric or wet-strength paper. The two substrates are heat-sealed together along the edge regions 4 and also
20 in a grid pattern 5, indicated in Figure 1 by dotted lines, to form a plurality of compartments 6, each approximately 1.3 x 1.3 cm, each containing a 1 cm x 1 cm square 7 of porous polymeric material, which may be dry or may carry a liquid. For clarity the thickness of the article 1 in
25 comparison to its surface area have been greatly exaggerated.

Referring now to Figures 3 and 4 of the drawings, a second article 8 consists of a lower substrate 9 and an

upper substrate 10, each consisting of a layer 11 of nonwoven fabric or wet-strength paper and, laminated thereto on one side only, a thin film 12 of polyethylene. The substrates 9 and 10 are so positioned with respect to one another that the polyethylene-coated sides 12 are in
5 contact. The polyethylene layers 12 of the two substrates are heat-sealed together along the edge regions 13 and also in a grid pattern 14, indicated in Figure 3 by dotted lines, to form a plurality of compartments 15, each approximately 1.3 x 1.3 cm, each containing a 1 cm x 1 cm
10 square 16 of porous polymeric material carrying liquid. Perforations 17 are provided in the upper layer 10, the numbers of perforations in each compartment varying, so that, for example, the compartment 15a will release its contents considerably more rapidly than compartment 15b
15 when the article is subjected to hand pressure. For clarity the size of the perforations 17, as well as the thickness of the article 1 in comparison to its surface area, have been greatly exaggerated.

The invention is further illustrated by the
20 following non-limiting Examples.

Examples 1 to 32 - Preparation of porous polymers

EXAMPLE 1

10 ml of styrene, 0.5 ml commercial divinylbenzene containing 0.25 ml ethyl vinyl benzene, and 2 g emulsifier
25 (Sorbitan monoleate "Span" (Trade Mark) 80) were mixed together in a plastic beaker at 15°C. A protective film was placed over the beaker after the stirrer was positioned to reduce the evaporation of the monomers. The stirrer speed was adjusted to about 300 rpm, 0.7 gm of potassium
30 persulphate was dissolved in 350 ml of distilled water and

the resulting solution was then added into the beaker drop by drop until the total 350 ml of the solution had been added. In this way a thick creamy white stable emulsion was obtained and this emulsion was polymerised in a sealed plastic container at 50°C for three days. The resulting
5 water-filled polymer had a water content of 96.6% by weight, yet it felt only slightly damp to the touch and water could be expelled only by pressing or squeezing. It was cut into small blocks and was dried under a dry atmosphere at 25-30°C. The dried polymer had a semi-
10 flexible structure and interconnected voids. Its dry density was 0.037 g/cc and its pore volume was 27 cc/g.

A sample of this polymer was placed in oleic acid and was found to absorb at least 30 times its own weight of the acid in about 10 minutes; also when the polymer was
15 placed in a mixture of oleic acid and water it absorbed effectively only the oleic acid.

EXAMPLE 2

10 ml styrene, 0.25 ml divinylbenzene, and 2 g "Span" (Trade Mark) 80 were mixed together at 25°C in a plastic
20 beaker. 300 ml of a 0.2% solution of potassium persulphate in distilled water were added to the monomer phase and polymerisation was carried out at 60°C for 8 hours by exactly the same procedure as described in Example 1. The water-filled polymer had a water content of 96.2% by
25 weight. A sample of the dried polymer, when placed in heavy grade liquid paraffin of density at 20°C, 0.870-0.890 and viscosity 178 cp at 25°C it absorbed about 20 times its own weight of the paraffin. The polymer had a dry density of 0.044 g/cc and a pore volume of 22 cc/g.

EXAMPLE 3

8.5 ml of styrene, 1.0 ml monooctyl itaconate, 0.5 ml divinylbenzene, 0.2 ml di-2-ethyl hexyl peroxydicarbonate (as an initiator) and 2 g of nonyl phenol/1.5 EO (Antarox
5 (Trade Mark) C 0210) were mixed together at 15°C. 200 ml of distilled water was added into the monomer phase and polymerisation was carried out at 50°C for 24 hours, following the same procedure as set out in Example 1. The water-filled polymer had a water content of 94.9% by
10 weight. A sample of the dried polymer, when placed in oleic acid, absorbed about 15 times its own weight of oleic acid. The polymer had a dry density of 0.061 g/cc and a pore volume of 16 cc/g.

EXAMPLE 4

15 5 ml of styrene, 5 ml of butyl methacrylate, 0.25 ml of allyl methacrylate (as a cross-linking agent) and 2 g of Span 80 were mixed together at 20°C in a plastic beaker. 300 ml of 0.2% solution of potassium persulphate was added to the monomer phase and polymerisation was
20 carried out by exactly the same procedure as described in Example 1. The dried polymer, when placed in perfume, absorbed about 50 times its own weight of perfume and subsequently released it very slowly. The dried polymer had a flexible structure.

25

EXAMPLE 5

10 ml styrene, 1 ml divinylbenzene (50% ethyl vinylbenzene), 2 g Span 80 were mixed together. 450 ml of 0.2% solution of sodium persulphate in distilled water was added to the monomer phase and the resulting emulsion,
30 which contained 97.8% internal phase, was polymerised in exactly the same way as described in Example 1. The

polymer, when dried, absorbed about 40 times its own weight of oleic acid. After removing the soluble impurities by methanol, using a Soxhlet extractor, the polymer absorbed about 43 times its own weight of oleic acid. The dry
5 density of the polymer after drying was 0.025 cc/g.

EXAMPLE 6

Using the general procedure of Example 1, a polymer was prepared from the following ingredients:

	α -methyl styrene	10 ml
10	divinyl benzene	1 ml
	Span (Trade Mark) 80	2 g
	Water (containing 0.1% sodium persulphate)	200 ml

The resulting water-filled polymer had a water content greater than 90% by weight.

15

EXAMPLE 7

Using the general procedure of Example 1, a polymer was prepared from the following ingredients:

	styrene	5 ml
	α -methyl styrene	5 ml
20	divinyl benzene	1 ml
	Span (Trade Mark) 80	2 g
	Water (containing 0.1% sodium persulphate)	300 ml

The resulting water-filled polymer had a water content greater than 95% by weight.

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EXAMPLE 8

Using the general procedure of Example 1, a polymer was prepared from the following ingredients:

vinyl versatate (Trade Mark) (higher esters	
5 of vinyl acetate, ex Shell)	10 ml
divinyl benzene	1 ml
Span (Trade Mark) 80	2 g
Water (containing 0.1% sodium persulphate)	200 ml

The resulting water-filled polymer had a water
10 content greater than 90% by weight.

EXAMPLE 9

Using the general procedure of Example 1, a polymer was prepared from the following ingredients:

styrene	5 ml
15 vinyl versatate (Trade Mark)	1 ml
divinyl benzene	1 ml
Span (Trade Mark) 80	2 g
Water (containing 0.1% sodium persulphate)	200 ml

The resulting water-filled polymer had a water
20 content greater than 90% by weight.

EXAMPLE 10

Using the general procedure of Example 1, a polymer was prepared from the following ingredients:

styrene	5 ml
2-ethylhexyl acrylate	5 ml
divinyl benzene	1 ml
Span (Trade Mark) 80	2 g
5 Water (containing 0.1% sodium persulphate)	200 ml

The resulting water-filled polymer had a water content greater than 90% by weight.

EXAMPLES 11 to 32

Using the general procedures set out in Example 1 work
10 was carried out using the materials set out below and in Table III which gives data on Examples 11 to 32.

Key to materials used in Examples 11-32
and set out in Table III

15 Materials used in external phase

- A styrene
- B butyl styrene
- C butyl methacrylate
- D ethyl methacrylate
- 20 E approx. 50% divinylbenzene + 50% ethyl vinyl benzene
- F Allyl methacrylate
- G N-octadecyl succinic acid
- H Sorbitan mono-oleate (Span (Trade Mark) 80)
- J Bis-(2-hydroxyethyl)octadecylamine)
- 25 K Alkyl benzene sulphonic acid (Dob 102) and dimethyl hardened tallow amine oxide (Arromox (Trade Mark) DMHTD)
- L Partial fatty acid esters of polyglycerol (Admul (Trade Mark) Wol 1403)
- N benzyl peroxide

30 Materials used in internal phase

- O water
- P glycerol
- Q sodium persulphate

R potassium persulphate

S 2,2-azobis-(2-amidenopropane)hydrochloride

Table III

	<u>Constituents</u>	<u>Ex.11</u>	<u>Ex.12</u>	<u>Ex.13</u>	<u>Ex.14</u>	<u>Ex.15</u>	<u>Ex.16</u>
5	A (ml)	10	10	10	10	5	5
	B (ml)						
	C (ml)						
	D (ml)						
	E (ml)	1	1	1	1	0.5	0.5
10	F (ml)						
	G (g)						
	H (g)	2	2	2	1		
	J						1
	K					1	
15	L						
	N (% on monomer)						
	O (ml)	300	200	150	100	100	100
	P (ml)						
	Q (% internal	0.2	0.2	0.2	0.08	0.15	0.15
20	phase)						
	R (% internal						
	phase)						
	S (% internal						
	phase)						
25	<u>Properties</u>						
	% internal phase						
	to monomers	96.5	94.8	93.2	90.1	94.8	94.8
	Approx. oil						
	uptake (w/w)	23	12	10	8	12	13
30	Approx. dry						
	density g/cm ²	0.04	0.065	0.082	0.099	0.06	0.06

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Table III contd.

	<u>Constituents</u>	<u>Ex.17</u>	<u>Ex.18</u>	<u>Ex.19</u>	<u>Ex.20</u>	<u>Ex.21</u>	<u>Ex.22</u>
	A (ml)	5	10		9	9	5
	B (ml)			5			
5	C (ml)				1		
	D (ml)					1	
	E (ml)	0.5	1	0.5	1	1	5
	F (ml)						
	G (g)	1					
10	H (g)			1	2	2	2
	J						
	K						
	L		2				
	N (% on monomer)						
15	O (ml)	100	200	100	300	300	300
	P (ml)						
	Q (% internal phase)	0.15	0.2	0.5	0.2	0.2	0.1
20	R (% internal phase)						
	S (% internal phase)						
	<u>Properties</u>						
	% internal phase						
25	to monomers	94.8	94.8	94.8	96.5	96.5	96.5
	Approx. oil uptake (w/w)	13	12	15	24	24	20
	Approx. dry density g/cm ³	0.06	0.065	*0.055	0.04	0.040	0.045

30 * Dry density after washing with methanol/water.

5	<u>Table III contd.</u>					
	<u>Constituents</u>	<u>Ex.23</u>	<u>Ex.24</u>	<u>Ex.25</u>	<u>Ex.26</u>	<u>Ex.27</u>
	A (ml)	1	8	10	10	10
	B (ml)					
	C (ml)		2			
10	D (ml)					
	E (ml)	9		1	1	1
	F (ml)		1			
	G (g)					
	H (g)	2	2	2	2	2
15	J					
	K					
	L					
	N (% on monomer)			1		
	O (ml)	300	200	200	200	240
20	P (ml)					60
	Q (% internal phase)	0.1				0.2
	R (% internal phase)		0.1			
25	S (% internal phase)				0.1	
	<u>Properties</u>					
	% internal phase to monomers	96.5	94.8	94.8	94.8	96.5
30	Approx. oil uptake (w/w)	20	13	12	12	24
	Approx. dry density g/cm ³	0.042	0.06	0.06	0.06	*0.034

* Dry density after washing with methanol/water.

5 Table III contd.

<u>Constituents</u>		<u>Ex.28</u>	<u>Ex.29</u>	<u>Ex.30</u>	<u>Ex.31</u>	<u>Ex.32</u>
10	A (ml)	10	15	15	15	15
	B (ml)					
	C (ml)					
	D (ml)					
	E (ml)	1	1	1	1	1
	F (ml)					
	G (g)					
	H (g)	2	1	2	3	4
15	J					
	K					
	L					
	N (% monomer)					
	O (ml)	100	200	200	200	200
20	P (ml)	100				
	Q (% internal phase)	0.2	0.2	0.2	0.2	0.2
	R (% internal phase)					
25	S (% internal phase)					
<u>Properties</u>						
	% internal phase to monomers	94.8	92.6	92.6	92.6	92.6
30	Approx. oil uptake (w/w)	13	9	12	11	10
	Approx. dry density g/cm ³	*0.06	0.08	0.078	0.083	0.087

* Dry density after washing with methanol/water.

EXAMPLE 33

Preparation of a Thin Film of Porous Polymeric Material

An emulsion was prepared as described in Example 1 using 30 ml styrene (distilled), 3 ml divinylbenzene (distilled), 6 g of Span 80, and 900 ml distilled water containing 1.8 g sodium persulphate. The emulsion was prepared at a stirrer speed of 300 r.p.m. and left for a further 30 minutes at this speed before polymerisation was started.

10 The polymerisation was carried out in such a way as to yield thin sheets, 18 cm x 18 cm x 0.16 cm. Two glass plates were rendered superficially hydrophobic, and a 0.16 cm thick strip of neoprene rubber was stuck around the edge of one plate to define a square cavity 18 cm x 18 cm. The
15 cavity was filled with the emulsion, the second plate placed upon the first, and the two plates clipped together. The assembly was placed in a water bath at 50°C for 24 hours. The polymerised material could then easily be removed as a sheet, which could readily be cut into 1 cm x
20 1 cm squares using a scalpel and straight-edge.

EXAMPLES 34 & 35

Preparation of articles for absorbing hydrophobic liquids

EXAMPLE 34

A sheet of polymerised material as prepared in
25 Example 33 was dried under a dry atmosphere at 25-30°C. Its dry density was 0.037 g/cc and its pore volume was 27 cc/g.

The sheet was placed between two sheets of a polypropylene/viscose nonwoven fabric ("Novalene" (Trade Mark) US 15) and the sheets were heat-sealed together at their edges to form a sachet.

- 5 The article thus formed was used to mop up a pool of oleic acid. The amount of oleic acid absorbed was approximately 30 times the weight of the polymer.

EXAMPLE 35

- 10 An article of the construction described above with reference to Figures 1 and 2 of the accompanying drawings was prepared as a product for mopping up hydrophobic liquids. The substrate layers each consisted of a polypropylene/viscose nonwoven fabric, and were sealed together at the edges and in a grid pattern by heat-
- 15 sealing. The size of the article was 30 cm x 30 cm and the compartments were each 1.3 cm x 1.3 cm. Each compartment contained 1 cm x 1 cm square of a polymer prepared as in Example 33 and dried as in Example 34.

- 20 The article was used to mop up a pool of oleic acid, and the amount of oleic acid absorbed was approximately 30 times the weight of the polymer.

EXAMPLES 36-49 - Preparation of porous polymer containing streak-free cleaning compositions

EXAMPLE 36

- 25 A liquid composition was prepared as follows:

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g by w:

Nonionic surfactant: C₁₂-C₁₅ primary
straight-chain alcohol, condensed with 7
moles of ethylene oxide

10

- 5 Partially esterified resin: partial ester
of a styrene-maleic anhydride copolymer,
neutralised to the sodium salt (average
molecular weight 10000; theoretical acid
number 190)

2

- 10 Demineralised water, perfume

to 100

This composition was then diluted 100-fold in
demineralised water.

- 15 A polymer was prepared as described in Example 2 and
dried under a dry atmosphere at 25-30°C. The dried polymer
was washed out several times with ethanol, using a Soxhlet
extractor, and then dried again in a dry atmosphere at
25-30°C. It was then filled under vacuum with the liquid
composition given above. The liquid uptake was 96% by
weight.

- 20 The resulting polymeric material containing a liquid
cleaning composition was a solid block feeling only
slightly damp to the touch. Liquid could be expelled only
by pressing or squeezing.

EXAMPLE 37

- 25 A streak-free cleaning composition was made up as
follows:

- Nonionic surfactant: C_9-C_{11} primary straight-chain alcohol condensed with 5 moles of ethylene oxide (Dobanol 91-5 ex Shell) 0.095
- 5 Partially esterified resin: partial ester of a styrene-maleic anhydride copolymer, neutralised to the sodium salt (average molecular weight 10 000; theoretical acid number 190). (Scripset 550 ex Monsanto) 0.01
- 10 Demineralised water to 100

A thin polymer film was prepared as described in Example 33 and cut into 1 cm x 1 cm squares using a scalpel and straight-edge. The squares were Soxhlet extracted with methanol for 6 hours, dried in an oven at 30°C, and 15 evacuated in a suitable vessel for 30 minutes. The vessel was isolated, the pump turned off, and the streak-free composition given above was sucked in. This process was repeated after 15 minutes; it took about 1 hour for the squares of polymer to become filled.

- 20 The filled polymer squares, containing more than 95% liquid, felt only slightly damp to the touch, and liquid could be expelled only by pressing or squeezing.

EXAMPLES 38-49

The procedure of Example 37 was repeated with a 25 number of different non-streak formulations, all in demineralised water, as follows:

5	<u>Example</u>	<u>Formulation</u>
	38	Nonionic surfactant as in Example 37 (0.095%), vinyl methyl ether/maleic anhydride copolymer partially esterified with butanol (Gantrez ES 425 ex GAF Corporation) (0.01%)
10	39	Tallow alcohol (C ₁₈), 18EO (0.1%)
	40	C ₁₃ -C ₁₅ oxo alcohol, 20EO (Synperonic (Trade Mark) 20 ex ICI) (0.1%)
	41	Nonyl phenol 18EO (0.1%)
	42	Nonyl phenol 30EO (0.1%)
15	43	C ₁₂ -C ₁₄ alkyl ether (3EO) sulphate (Empicol (Trade Mark) ESB 70 ex Albright & Wilson) (0.1%)
	44	C ₁₀ -C ₁₂ linear alkylbenzene sulphonate (Dobs (Trade Mark) 102 ex Shell) (0.06%)
20	45	C ₁₀ -C ₁₂ linear alkylbenzene sulphonate (0.12%) and C ₁₂ -C ₁₅ alkyl ether sulphate (Dobanol (Trade Mark) 25 ex Shell) (0.03%)
	46	Sodium di(2-ethylhexyl) sulphosuccinate (0.12%), C ₁₁ -C ₁₅ secondary alcohol 12EO (0.09%), ethanol (0.13%)
25	47	Tallow alcohol 18EO (0.1%) Isopropanol (10.0%) Ammonia (35% solution) to pH 10

- 48 C₁₂-C₁₅ alkyl ether sulphate 3EO (0.1%)
C₉-C₁₁ linear primary alcohol 5EO (0.03%)
Partially esterified resin as in Example 37
(0.01%), Isopropanol (10.0%), Ammonia (35%
5 solution) to pH 10
- 49 Ammonium soap of 50% coconut/50% oleic acid
(0.005%), partially esterified resin as in
Example 37 (0.1%).

10 In each case the filled polymer squares contained
more than 95% liquid and felt only slightly damp to the
touch, and liquid could be expelled only by pressing or
squeezing.

EXAMPLES 50-64 - Preparation of streak-free cleaning
articles

15

EXAMPLE 50

A thin polymer film, 7 cm x 7 cm, was prepared as
described in Example 33 and the water in the polymer was
replaced by the streak-free cleaning composition of Example
37, using the method described in that Example.

- 20 The sheet of liquid-containing polymer was placed
between two sheets, with 7.6 cm x 7.6 cm, of a
polypropylene/viscose nonwoven fabric ("Novalene" (Trade
Mark) US 15), which had previously been washed in boiling
demineralised water, rinsed in cold demineralised water and
25 dried. The sheets were heat-sealed together at their edges
to form a sachet.

- The sachet was then used to wipe over a clean black
glazed ceramic tile using the following procedure. The
sachet was first positioned over the tile surface and
30 pressed against the surface with the fingers to express a

suitable quantity of liquid onto the surface. The sachet was then used to spread the liquid over the surface. The tile was allowed to dry naturally and its surface was shining and streak-free.

5

EXAMPLE 51

A thin polymer film containing a streak-free cleaning composition was prepared as in Example 50 and was placed between two sheets, each 7.6 cm x 7.6 cm, of a laminated substrate consisting of a base layer of nonwoven
10 fabric ("Storalene" (Trade Mark) 610:60, consisting of 40% cotton linters, 55% viscose and 5% polyamide) with a thin layer of polyethylene extrusion-coated thereon. The nonwoven fabric had previously been washed as described in
15 Example 50 to remove streak-forming impurities. The two sheets were positioned with their polyethylene layers adjacent to one another and were heat-sealed together at the edges to form a sachet. Using a syringe needle of diameter 0.8 mm a number of perforations were made in the upper wall of the sachet.

20

The sachet was used to wipe over a clean black glazed ceramic tile as described in Example 50, the liquid being expressed through the perforations on to the tile surface. The tile was left shining and streak-free after natural drying.

25

EXAMPLE 52

An article of the construction described above with reference to Figures 1 and 2 of the accompanying drawings was prepared for use as a non-streak cleaning product. The substrate layers each consisted of a polypropylene/viscose
30 nonwoven fabric ("Novalene" (Trade Mark) US 15) which had been prewashed in boiling demineralised water. The size

of the article was 30 cm x 30 cm and the compartments were each 1.3 cm x 1.3 cm. Each compartment contained a 1 cm x 1 cm square of the liquid-containing polymer prepared in Example 37.

- 5 The article was used, as described in Example 50, to wipe a clean black glazed ceramic tile. The surface of the tile was left shining and streak-free after natural drying.

EXAMPLE 53

- 10 An article of the construction described above with reference to Figures 3 and 4 of the accompanying drawings was prepared for use as a non-streak cleaning product. The substrate layers each consisted of a nonwoven fabric (Tampella (Trade Mark) K286 blue, a wet-laid nonwoven fabric consisting of 80% viscose and 20% woodpulp, base weight 50 g/m²) extrusion-coated with a 20-30 μ m layer of polyethylene, (Alkathene (Trade Mark) 7 ex ICI), and prewashed in boiling demineralised water. The size of the article was 30 cm by 30 cm, and the compartments were each 1.3 cm x 1.3 cm. Each compartment contained a 1 cm x 1 cm square of the liquid-containing polymer prepared in Example 20 37. The substrates were perforated at 2 to 4 holes/cm².

- 25 The article was used, as described in Example 50, to wipe a clean black glazed ceramic tile. The surface of the tile was left shining and streak-free after natural drying. 60% of the liquid contained in the polymer could readily be expelled from the article by hand pressure, the remainder being retained in the polymer and substrate.

EXAMPLES 54-65

- 30 Example 53 was repeated using the polymer squares prepared in Examples 38-49 and similar results were

obtained: about 60% of the liquid was delivered in each case and streak-free results were obtained in the black tile test.

EXAMPLE 66

5 Preparation of an Article for Bleaching Stains on Textile Fabrics

A polymer was prepared as in Example 1, using the following materials:

	Styrene	10 ml
10	Divinyl benzene	1 ml
	Span 80	28 g
	water (25% hydrogen peroxide, 0.2% potassium persulphate)	300 ml

15 A piece of the resulting hydrogen-peroxide-containing polymer was incorporated in a sachet as described in Example 34. The sachet was used as a stain remover on textile fabrics.

CLAIMS

1. An article suitable for delivering or absorbing a liquid, characterised in that it comprises a substrate carrying a pressure-sensitive porous polymeric material capable of retaining at least 5 times its own weight, defined in terms of water, of liquid and of releasing at least some of said liquid on the application thereto of hand pressure, the porous polymeric material being dry or containing an aqueous or non-aqueous liquid.
2. An article as claimed in Claim 1, characterised in that it is capable of retaining at least 10 times its own weight of liquid defined in terms of water.
3. An article as claimed in Claim 1, characterised in that the porous polymeric material is capable of retaining at least 25 times its own weight of liquid, defined in terms of water.
4. An article as claimed in any one of Claims 1 to 3, characterised in that the porous polymeric material has a dry density of less than 0.1 g/cc.
5. An article as claimed in any one of Claims 1 to 4, characterised in that the porous polymeric material comprises linked pores having a pore volume of more than 9 cc/g.
6. An article as claimed in any one of Claims 1 to 5, characterised in that the porous polymeric material is the polymerisation product of a high internal phase emulsion having an aqueous internal phase.

7. An article as claimed in Claim 6, characterised in that the porous polymeric material is the polymerisation product of a high internal phase emulsion having an aqueous internal phase which constitutes at least 90% by weight of the emulsion.
8. An article as claimed in any one of Claims 1 to 6, characterised in that the porous polymeric material is a vinyl polymer.
9. An article as claimed in Claim 8, characterised in that the porous polymeric material is a styrene polymer.
10. An article as claimed in any one of Claims 1 to 9, characterised in that the substrate comprises one or more layers of paper and/or nonwoven fabric.
11. An article as claimed in any one of Claims 1 to 10, characterised in that the porous polymeric material is enclosed within a sachet, at least one wall of said sachet being permeable to liquid.
12. An article as claimed in Claim 11, characterised in that it comprises a first substrate layer and a second substrate layer so bonded together as to create a plurality of compartments therebetween, at least some of said compartments containing said porous polymeric material and at least some of said compartments being permeable to liquid.

13. An article as claimed in any one of Claims 1 to 12, characterised in that the porous polymeric material contains a homogeneous aqueous liquid composition having a surface tension of less than 45 mNm^{-1} , which composition, when applied to a surface and allowed to dry, dries substantially without forming discrete droplets or particles larger than $0.25 \text{ } \mu\text{m}$.

14. An article as claimed in any one of Claims 1 to 13, characterised in that the porous polymeric material contains an aqueous liquid comprising a surface-active agent.

15. An article as claimed in any one of Claims 1 to 12, characterised in that the porous polymeric material contains an aqueous liquid comprising a partially esterified resin.

Fig.1.

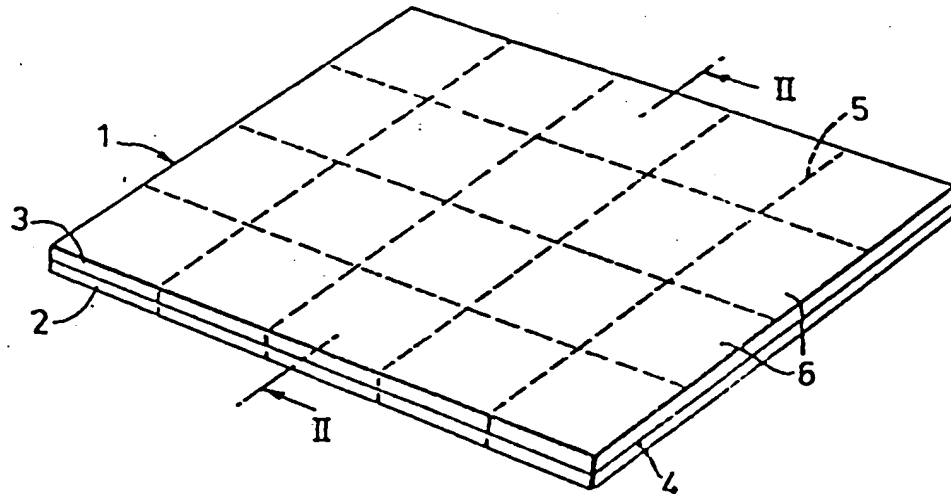
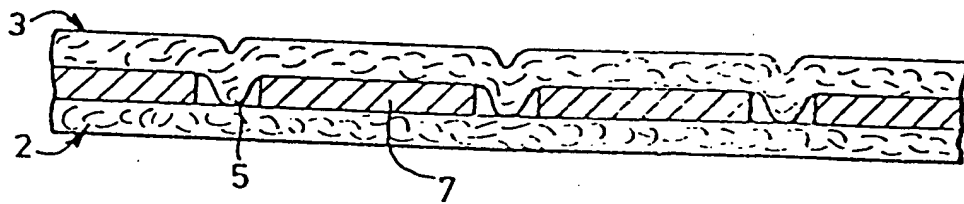
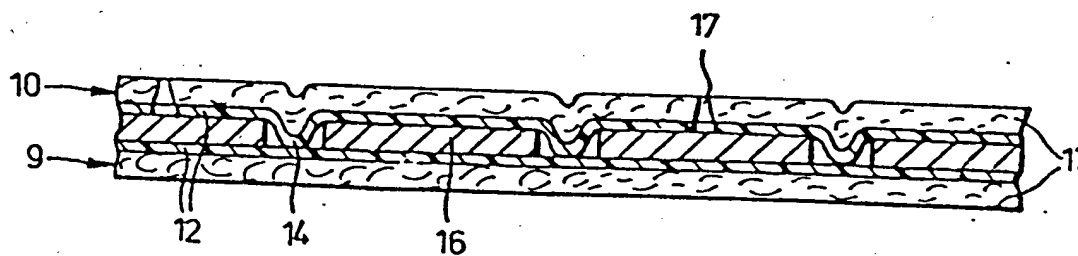
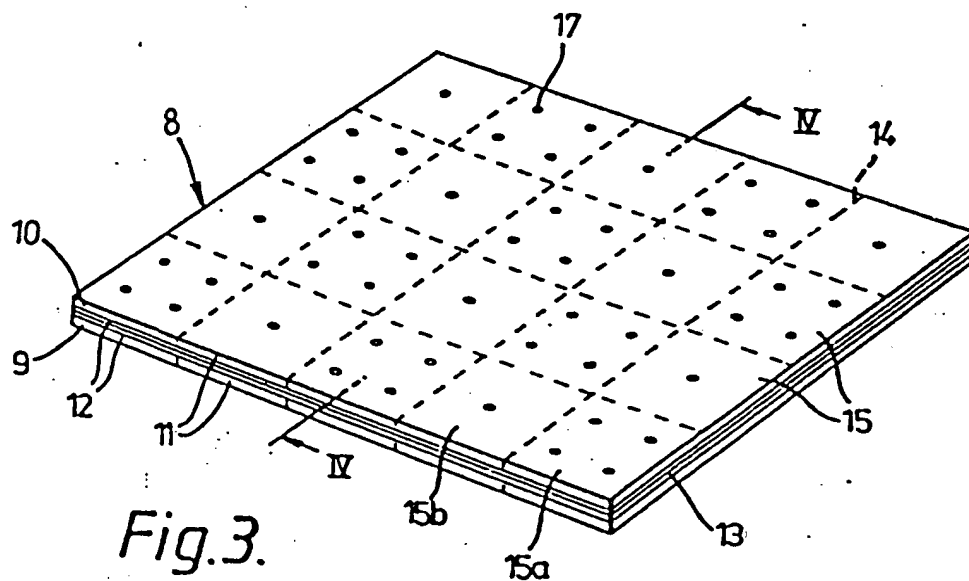


Fig 2







European Patent
Office

EUROPEAN SEARCH REPORT

Application number
0068830

EP 82 30 3307

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl. 7)
A	US-A-3 720 534 (NORMAN MACAULEY) *Column 1, line 58 - column 2, line 59, column 3, line 21 - column 5, line 21*	1	A 61 L 15/00
A	--- AU-B- 32 006 (ADRESSOGRAPH-MULTIGRAPH CORP.) *Page 5, paragraph 3; page 6, paragraph 2 - page 11, paragraph 1*	1	
A	--- GB-A- 952 075 (GUNTHER WILL) *Page 2, lines 16-76; page 3, lines 26-87*	1	
			TECHNICAL FIELDS SEARCHED (Int. Cl. 7)
			A 61 L C 08 J
The present search report has been drawn up for all claims			
Place of search THE HAGUE		Date of completion of the search 29-09-1982	Examiner SCHRIJVERS H.J.
CATEGORY OF CITED DOCUMENTS			
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